



Technical Data Sheet

Qr Resin QR-1335IM(V)

Polycarbonate + PET
 LyondellBasell Industries
 Engineering Plastics

Product Description

Appearance:
 Natural/Black Color
 Custom Colors Available

Features:
 High Impact (at room temperature and low temperature)
 Chemically Resistant
 UV (V) Stabilized

General

Additive	• UV Stabilizer		
Features	• Chemical Resistant	• High Impact Resistance	• Low Temperature Impact Resistance
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.21	1.21 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 Kg)	35 g/10 min	35 g/10 min	ASTM D1238

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	8500 psi	58.6 MPa	ASTM D638
Tensile Elongation (Break)	130 %	130 %	ASTM D638
Flexural Modulus	300000 psi	2070 MPa	ASTM D790
Flexural Strength	11500 psi	79.3 MPa	ASTM D790

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	12 ft·lb/in	640 J/m	ASTM D256

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 Psi (1.8 Mpa), Unannealed	255 °F	124 °C	ASTM D648

Technical Data Sheet

Qr Resin QR-1335IM(V)

Polycarbonate + PET
 LyondellBasell Industries
 Engineering Plastics



Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	230 °F	110 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Rear Temperature	480 to 520 °F	249 to 271 °C
Middle Temperature	490 to 530 °F	254 to 277 °C
Front Temperature	500 to 540 °F	260 to 282 °C
Nozzle Temperature	490 to 530 °F	254 to 277 °C
Processing (Melt) Temp	500 to 530 °F	260 to 277 °C
Mold Temperature	150 to 190 °F	66 to 88 °C

Notes

These are typical property values not to be construed as specification limits.